Work Orde September-11-1.		11.4	0.1.0	*106	5729*		Page					
Item ID: Revision ID: Item Name:	646.3910 Shim	646.3 B1067	29	Accept	*N900	040	100)* s	Setup Star	IV	S1* S2*	
Start Date: Required Date: Reference:	9/23/13 9/23/13	Start Qty: 40.00 Req'd Qty: 40.00	*4(*4(· -	Cust Item I Customer:	D:						
Approvals:		an: MCZ	Date: <u>\3</u> -06	7-\2Tooling: SPC (Y/N):		ite:		F	Run Stai Sto	" [V]	R1* R2*	- magnetic
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr		vision Nbr										
646.3900 110 *1 1 0 * Waterjet FLOW CNC Waterj	N/C	Memo 1-Cut as per Dwg Rev:_	r Dwg	0.00				40	6		Au 13:11	3 3 5
120		Prog Rev:	necessary	0.00				·				:
120 QC QC Ouality Control		Memo		0.00				40			Ac 13.1	·

Quality Control

		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

											QA Closed:	Date	2:
Work Orde	or.					DISPOSITION		•		AGAINST DE	PARTMENT	/PROCESS	
Part I	No.					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	Ī	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty	,	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator						•							
Material						,							
Setup													
Other													
Process			ļ		<u> </u>								
Supplier	_												
Training	ldash		İ										
Unapproved	<u> </u>		<u> </u>		<u> </u>						J	1	1
ļ							AUL	T CATE	GORY				
Landi	ing (7			[General					۱	Г	¬。
	┝	Bending			0/5	Bend BONA/Double	\vdash	Grain			Ovalized	<u></u>	Pressure/Forced
	\vdash	Centre No Cracks	ot Concei	ntric to	^{0/3} -	BOM/Route Broken/Damaged		Hardwa	ire ion Incomplete		Over/Under Part Incorre	-	Temperature/Cure Weld
	\vdash	Crushed/	Crimpod		-	Burrs	-		ion incomplete/	Unclear	Part Lost/Mi	i —	Wrong Stock Pulled
	\vdash	Cuffs	Cimpeu			Contamination	-	Mainte		Officieal	Part Moved	issuid [Wrong Stock Fulled
	\vdash	Heat Trea	at		<u> </u>	Countersink	-	Mislabe		 	Positioned V	Mrong	
		Inspectio		Tube		Cut Too Short		Misrea		<u> </u>	Power Loss/		Other
		Ripples in	-		<u> </u>	Drill Holes	\vdash	Offset		<u> </u>	_		1
	\vdash	Torque W		Extrusio	n	Drawing			Calibration				
	\vdash	Turning S				Finish		l	Sequence				
	Г	Wave/Tw				Folio			Dimensions				

Work Order ID 106729 September-11-13 11:34:50 AM			Page 2				
Item ID: Revision ID: Item Name:	646.3910 Shim			Accept	*N90004	IN1NN* s	etup Start *NS1* Stop *NS2*
Start Date: Required Date: Reference:	9/23/13	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		Cust Item ID: Customer:		IVI
Approvals:		an:	Date:	Tooling: SPC (Y/N):	Date:		Start *NR1* Stop *NR2*
Sequence ID/ Work Center II 130 *1 30* QC Quality Control	D	Operation Description QC8- Inspect parts - secon	d check	Set Up/ Run Hours 0.00 DAS 27 0.00 S S		Ol# Plan Accept Code Qty Color Color	Reject Reject Insp. Qty Number Stamp
140 *140* Outsource3 Outsource process	· Cad plate	Outsource process-Cadpla Memo Issue P/O:	te per QSI017 4.1.9.1	0.00		_CX	(13/11/06 (90)
150 *150* Packaging Packaging		Receive & Inspect for Dan	nage & Mat'l Certs	0.00		40x	13-12-4

DAS 26 9-89

CRA

			DQA: _	Date:	
NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE		

											QA Closed:	Date	e:	
Work Orde	r.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS		
Part N	lo					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	•	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update	1	nitial	Ac	tion	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification		QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
опаррточеи			L	1	<u> </u>	F	AUL	T CATE	GORY		1	L		
Landii	ng G	ear				General								
		Bending Centre No Cracks Crushed/o Cuffs Heat Trea Inspection Ripples in Torque W	Crimped at n Strip in n Bend Vaves in E	Tube Extrusio		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misrea Offset Out of	ion Incomplete tions Incomplete, enance eled d Calibration	/Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct Essing C		Pressure/Forced Femperature/Cure Weld Wrong Stock Pulled Other
		Turning S				Finish	_	1	Sequence					· · · · · · · · · · · · · · · · · · ·
1	l	Wave/Tw	ist in Tul	oe e	Į.	Folio		Outside	e Dimensions					

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Work Order ID 106	5729
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106729

Page 3

September-11-	13 11:34:50	AM		1()	6779								
Item ID: Revision ID: Item Name:	646.3910 Shim			Accept	*N900	040	100	ገ*	Setup	Start Stop	*N:	S1* S2*	:
Start Date: Required Date Reference:	9/23/13	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		Cust Item l Customer:	ID:					IVI		
Approvals:	Process P	lan:	Date:	Tooling:	D	ate:			Run	Start Stop	*N	R1*	
	QC:		Date:	SPC (Y/N):	D	ate:				Stop	*N	R2*	
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	t Re Qt		Reject Number	Insp. Stamp	
*160 *160*		QC5- Inspect part comple	eteness to step on W/O	0.00	DAS 27			40	ı				
QC Quality Control		Memo		0.00	12 12 14			(Oe)]				_
				_									•
170		Identify as per dwg & Sto	ock Location:	0.00							/		DAS 32
170 Packaging		Memo		0.00					- 7	6	13/12/	ó	9-89
Packaging		***IDENTII REV***	FY AS PER APICAL MP	PP-120 BY STAMPING	THE P# AND								1
180		QC21- Final Inspection -	Work Order Release	0.00						131			Δ
180 QC Quality Control		Memo		0.00						17/	12/	74	
Quality Control											/		
					,					NIO	10 'D		

MR10,5

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	ONF	ORN	MANCE / UPDATE				
										QA Closed:	Date:	
Work Orde	· ·				DISPOSITION	l		AGA	INST DE	PARTMENT	PROCESS	
WOIK OIGE					Rework	ı		Skid-tube Cross	tube		Water Jet	Engineering
Part N	lo.				Scrap			—	l Fab	Pro	d. Eng. Coor.	Quality
		······································			Use-as-is			Ŭ —I	shing		e/Packaging	Other
NCR N	lo.				Work Order Update			Large Fab Comp		•	Supplier	
										·		····
Root				Descri	ption of work order update	Init	1	Action		Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief	f Eng	Description		Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material							1				l E	
Setup												
Other												
Process						Ì						
Supplier												
Training												
Unapproved									<u>.</u>			
					F/	AULT (CATE	GORY				
Landi	ng Gear				General	_						-
	Bending			_	Bend	∐ G _i	rain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route	L Ha	ardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks			L	Broken/Damaged	∐ In:	specti	on Incomplete		Part Incorred	ct	Weld
	Crushed/	Crimped			Burrs	∐ In:	struct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
:	Cuffs				Contamination	\square M	lainte	nance		Part Moved		
	Heat Trea	at			Countersink	М	lislabe	led		Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

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Picklist Print

September-11-13 11:34:50 AM

Work Order ID:

106729

Parent Item:

646.3910

Parent Item Name:

Shim

Start Date: 9/23/13

Required Date: 9/23/13

Page 1

Start Qty: 40.00

Required Qty: 40.00

126423 --- 1,27

Comments:

IPP REV:A 12.12.23 NEW ISSUE DD VERF:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MC1095S.020 C1095 Blue Tempered Spr	ring Steel Sheet .020	Purchased	No			110	sf	28.4000	0.03	-1.26315 6	- Au	_ 13	111.0
				Location		Loc Oty	Lo	c Code					
				MAT022		28.4							
				1235	537	5.4							

23

m126423

												DQA:	L	Jate:	
NCR:	⁄es	/ No				WORK ORDER NON-C	10:	VFORM	MANCE / UP	DATE		QA Closed:		Date:	
Work Orde	or.					DISPOSITION				AGAINST D		PARTMENT			
Part I					Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Finishing		Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other	
Root		1			Descri	ption of work order update		Initial	Ac	tion	٦	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	$oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{oldsymbol{ol}}}}}}}}}}}}}}}}$	Date	Verificat	ion	QC Inspector
Doc/Data															
Equip/Tooling						•	1								
Operator			<u> </u>				ļ								
Material						·	1								
Setup															
Other]											
Process															
Supplier															
Training			1				١	•							
Unapproved															
			·			F	AUL	T CATE	GORY						
Landi	ng (Gear				General		_				-			_
		Bending				Bend		Grain		Ĺ	_	Ovalized		L	Pressure/Forced
		Centre N	ot Conce	ntric to	O/S	BOM/Route		Hardwa	re			Over/Under	tolerance	L	Temperature/Cure
]		Cracks				Broken/Damaged		Inspecti	ion Incomplete			Part Incorred	t		Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance	Γ		Part Moved			_
		Heat Trea	at			Countersink		Mislabe	eled			Positioned V	Vrong		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Turning Sequence
Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

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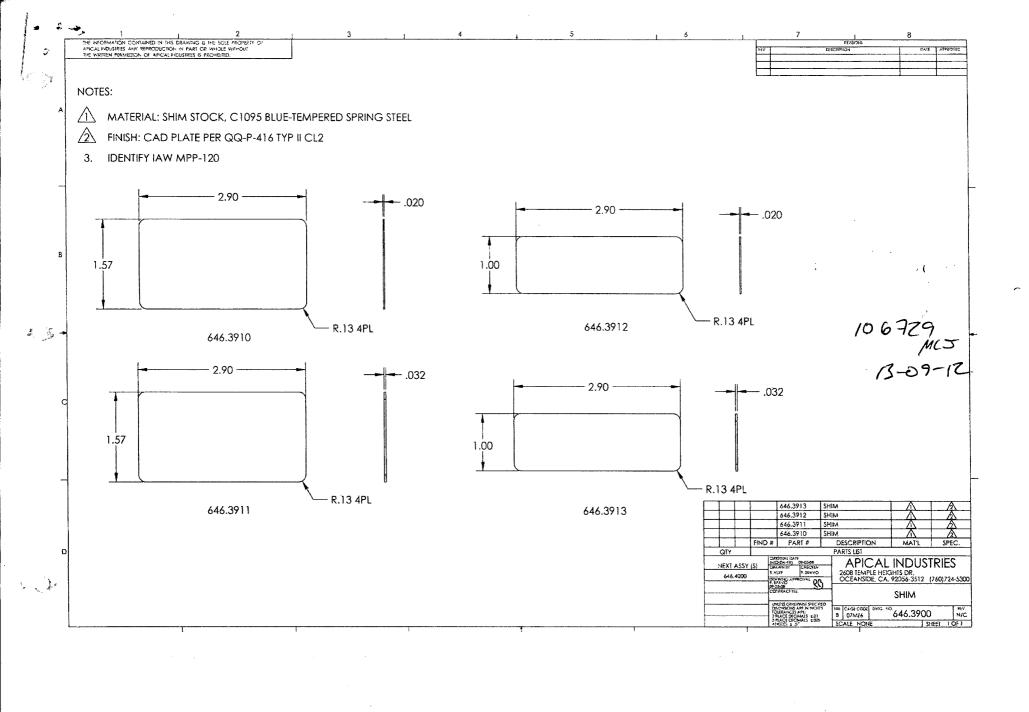
DART AEROSPACE LTD	Work Order:	106779
Description: Shim	Part Number:	646.3910
Inspection Dwg: 646.3900 Rev: N/C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	111/01	AKTICLE	OI LO III		OILLO!	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.57	+/-0.005	1,57	_		V	DKM-01
2.90	+/-0.005	2.90	_		V	
0.020	+/-0.005	,020			V	
			•			
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				· · · · · · · · · · · · · · · · · · ·		
					,	
aurad by	<u> </u>	Audited by:	DAS		Preliminary A	Innroval:

			DAS			
Measured by:	A	Audited by:	27	Prel	liminary Approval:	
Date:	13.11.02	Date:	12 11 CIU		Date:	

Rev	Date	Change	Revised by	A	Approved
A	12.11.30	New Issue	KJ	Y	AA
				$\boldsymbol{\pi}$	



CERTIFICATE OF CONFORMANCE

CADORATH PLATING CO. LTD. 2150 LOGAN AVENUE **WINNIPEG, MANITOBA R2J-0J1**

DATE:

Dec-02-2013

CONSIGNED TO: Dart Aerospace Ltd.

1270 Aberdeen St.

Hawksbury, ON K6A 1K7

W/O #:

130247

INVOICE #:

68742

CONTRACT OR

PURCHASE ORDER #

PO21961

DESCRIPTION:

SHIM

QTY

40

P/N# 646.3910

106729

CADMIUM PLATING IAW AMS-QQ-P-416C TYPE 2 YELLOW CLASS 2. BAKE HEAT CHART # 13-1051.

CERTIFICATE: I certify that the items indicated here on have been inspected and tested and conform to all specifications and requirements detailed on the contract or purchase order.



Approved Inspector: